

19-7537



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-2

Job Sheet 190684



Part No: D3278-2

Job Qty: 60 pcs

Part Name: Support



Part Weight: 0 lbs

Job Created: 2/13/19

Due Date: 2/26/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs		2/26/19	0.00	3.00	Bandsaw - 1		Bn
110	HAAS 5 Axis - B4B	60 pcs		2/26/19	0.06	25.75	HAAS - 5 - B4B		
120	Outsource	60 pcs		2/26/19			MEM001-VC		CT 19-03-01
123	Packaging 2-1 - Receive - B4B	60 pcs		2/26/19	0.00	0.00	Packaging 2 - 1 - B4B		APR 02 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dart.ca

Container No: S157809



Part: D3278-2

Job No: 190684

Serial No/Batch: S157809

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/28/19

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					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
126 QC 6	60 pcs	2/26/19	0.00	0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
130 QC 8	60 pcs	2/26/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
140 Handfinish - 1-1 Chemical-B4B	60 pcs	2/26/19	0.00	6.18	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	

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				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	60 pcs	2/26/19	0.00 1.23	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	60 pcs	2/26/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9

170	Packaging 3-1 - Stock - B4B	60 pcs	2/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	DAS
						Packaging 3 - 7 - B4B	28
						Packaging 3 - 8 - B4B	9-89
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
180	QC 21 - SA	60 pcs	2/26/19	0.00	0.00	QC 21 - SA - 21	
						QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long

Descriptions: 110 - (HAAS CNC vertical machine #5)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13.0200 ft (.217 ea)	100-Bandsaw - 1	5157420

7AT
used
13.025

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	13	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098Inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359Inches ± 0.005	0.364 0.354		
3	Support	0.609Inches ± 0.010	0.619 0.599		
4	Support	0.250Inches ± 0.010	0.260 0.240		
5	Support	1.480Inches ± 0.005	1.485 1.475		
6	Support	0.125Inches ± 0.010	0.135 0.115		
7	Support	0.119Inches + 0.005 - 0.004	0.124 0.115		
8	Support	2.439Inches ± 0.010	2.449 2.429		
9	Support	1.980Inches ± 0.010	1.990 1.970		
10	Support	0.130Inches ± 0.030	0.160 0.100		
11	Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
12	Support	0.375Inches ± 0.010	0.385 0.365		
13	Support	0.875Inches ± 0.010	0.885 0.865		
14	Support	0.500Inches ± 0.010	0.510 0.490		
15	Support	0.400Inches ± 0.010	0.410 0.390		
16	Support	1.000Inches ± 0.030	1.030 0.970		
17	Support	1.720Inches ± 0.010	1.730 1.710		
18	Support	0.125Inches ± 0.010	0.135 0.115		
19	Support	0.125Inches ± 0.010	0.135 0.115		

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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042758



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042758

PO Date: 3/1/19

Due Date: 4/2/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190685	D3278-2	Support : Various STC's	Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
	190684			Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
Sub Total:							120	0	120		\$3,006.00
2	190683	D3278-1	Support : Various STC's (Outsource process - Machining)	Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
	190682			Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
Sub Total:							120	0	120		\$3,006.00
Grand Total:											\$6,012.00

DAS
40
9-88



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042758



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/1/19 2:33 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24909
Shipment Date: 28-Mar-2019
Ship Via: Pick up at METEC
Order Number: 3559
Order Date: 03/01/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042758 ✓
Terms: Net 60 Days

----- Quantity -----								Job	
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number	
3	120	120 ✓	0	0	EA	D3278-2P Support, unpainted	C	3559-01	DAS 40 9-89
4	120	120 ✓	0	0	EA	D3278-1P Support, unpainted	C	3559-02	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
 Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

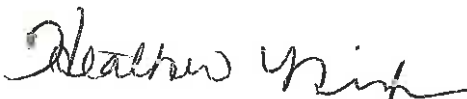
same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
60	D3278-1	Support	C	S157799	Unpainted	42758
60	D3278-2	Support	C	S157799	Unpainted	42758
60	D3278-1	Support	C	S157813	Unpainted	42758
60	D3278-2	Support	C	S157813	Unpainted	42758

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, March 28, 2019

Entered: 24 Date: Oct 24/19



NCR No. 19-7537 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>190684</u>		DISPOSITION		DEPARTMENT/PROCESS																												
Part No. <u>D3278-2</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																									
Date : <u>APR 02 2019</u>	Sequence #: <u>140 HANDFINISH 1-1</u>		QTY Affected : <u>+ 59</u>		MRB (QSI042)																											
Description Work Order Deviation			Disposition			<u>D1904.02</u>																										
<u>- PART IS CUT ON A TAPER, FROM 0.125" TO 0.055"</u> <u>PART IS SUPPOSED TO BE A CONSISTANT 0.125"</u>			<u>SCRAP</u>			Completed By <u>DAS</u> <u>68</u> <u>APR 02 2019</u>																										
						Lead hand / Supervisor 																										
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY																													
			<table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☒ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>					☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☒ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled
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Other/Details:																																